Qty:

Each

Um:

Date: User This Issue Prsht Rev. **Previous Run**

Wednesday, 3/14/2007 3:29:02 PM

Kim Johnston

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

: ANGLE

: D314085

: NIA

: 3/23/2007

: N/A

. D3140 REV F

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 31215 **Estimate Number** : 11459

: NA P.O. Number

: 3/14/2007

S.O. No. : 1/1/ : NC

Type

: 3/14/2007 First Issue

: 27375

Written By

Checked & Approved By Comment

Est. Rev B New dwg rev. ecn781 06.04.18 EC Est Rev:C As per ECN #829 06-11-20 JLM

: SMALL /MED FAB

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

5052-H32 .040 Sheet

M5052H32S040 1.0



0.3688 sf(s)/Unit Total: 1.4750 sf(s)

M5052H32S.040 SHEET

Batch MIOI &

SMALL FAB 2.0

Comment: Qty.:

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Cut as per dwg D3140 26.65" long

Deburr.

No sharp edges]

-Scuff surfaces with 80grit sandpaper per QSI 006 ~

Contour as per dwg

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Die

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



03

Page 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
l								

Part No: _	 PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: 07/03//
			QA: N/C C	losed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B	Verification	A				
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
₂ ,0	When forming the bend the mad.	Pasian	-destroy part	3/2	M 07/03/16	Vision	A) 07/03/16		
0	(Scrap 1 part)								
	STEP 3.0	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng When Forming the Corrective Action Section B Action Description Chief Eng Chief Eng Chief Eng	STEP Description of NC Section A Description of NC Section A Chief Eng Corrective Action Section B Initial Action Description Chief Eng Chief Eng Date	STEP Description of NC Section A Description of NC Section A Chief Eng Corrective Action Section B Verification Section C Section C	STEP Description of NC Section A Description of NC Section A Chief Eng Corrective Action Section B Initial Action Description Chief Eng Chief		

NOTE: Date & initial all entries

Date:

Wednesday, 3/14/2007 3:29:02 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 31215

Part Number: D314085

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: A

 \mathcal{A}

07/03/18

7.0

QC21

FINAL INSPECTION/W/O RELEASE



3)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U J.03.19

Dart Aerospace Ltd

W/O:		WORK ORDER O					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						·	
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	
			QA:	N/C Close	d:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B			A	A			
DATE	STEP	TEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
-											

NOTE: Date & initial all entries



DESIGN DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO,	
CHECKED APPROVED	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE	TITLE	SCALE
06.10.06	DOOR	NTS

RELEASED 06.11.13

		111-111
06.1	0.06	DOOR NTS
Α	02.04.18	NEW ISSUE
В	03.01.23	REMOVE -65/-81/-83; ADD -301/-303
С	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION]
X X	-00	-07	-08	703	-10	D3140-05	DOOR	1
\vdash	Х			 		D3140-06	DOOR	
	^_	х		-		D3140-07	DOOR	1
			x	-		D3140-08	DOOR	1
		1	 ^	X		D3140-09	DOUBLER ASSEMBLY	
		<u>'</u>	1	^-	X	D3140-10	DOUBLER ASSEMBLY	1
						20110 10		1
3	3		 	<u> </u>		D3140-57	PAD	
1	1		-			D3140-59	PAD	
2	2					D3140-61	PAD	1
2	2					D3140-63	PAD	1
-		1	1			D3140-69	PAD	1
		1	1			D3140-71	PAD	
		1	1			D3140-73	PAD	1
		1	1			D3140-75	PAD	
		1	1			D3140-77	PAD	1
		1	1			D3140-79	PAD	
				1	1	D3140-85	ANGLE	
1	1					D3140-87	DOUBLER SHO	P COPY
				1	1	D3140-89	DOUBLER RE	URN TO
		1				D3140-91	DOUBLER ENG	NEERING
<u> </u>			1			D3140-92	DOUBLER	ROLLED COPY
3	3					D3140-95	DOUBLER UNCORT	O AMENDMENT
1						D3140-97	DOUBLER SUBJECT	O AMENDMENT
	1					D3140-98	DOUBLER WITH	OUT NOTICE
		1	1			D3140-99	DOUBLER WO	RK ORDER
		2	2			D3140-101	DOUBLER NO.	31215
		1				D3140-103	DOUBLER	
			1			D3140-104	DOUBLER	<u> </u>
		1				D3140-105	DOUBLER]/D\
			1			D3140-106	DOUBLER	
1	1					D3140-241	DOUBLER	
1		1				D3140-301	DOUBLER	
	1		1			D3140-303	DOUBLER	
				5	5	MS20426AD3-4	RIVET	J

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN #	CB	1	ROSPACE LTD y, ontario, canada
CHECKED	APPROVED,	DRAWING NO.	REV. F
Mek	1 of	D3140	SHEET 2 OF 7
DATE		TITLE	SCALE
06.10.06		DOOR	итз



COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM



FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

ALL DIMENSIONS IN INCHES

RELEASED



MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION



DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION



RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130



PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND ALODINE PER DART QSI 005 4.1



SHOP COPY RETURN TO

ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

Copyright @ 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.









